

Work Order ID 131598

Friday, April 17, 2015 8:40:23 AM

131598

Page 1

Item ID: D3650-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Panel
Start Date: 4/17/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/24/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: MF Date: 15-4-17 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3650	Rev E								
100	FLOW WATER JET	0.00				8	0		Jm15-4-18
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3650								
304-48*	Dwg Rev: <u>E</u>								
	Prog Rev: <u>12</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				8	0		Jm15-4-18
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				8			
120									
QC	Memo	0.00							
Quality Control									

DAS
30
9-89

APR 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Page 2

Item ID: D3650-5

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Panel

Start Date: 4/17/2015 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 4/24/2015 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE				DAS	8			APR 27 2015
Brake NC	Memo	0.00			30				
Brake NC	Form as per Dwg D3650				9-89				
140		0.00							
140	QC5- Inspect part completeness to step on W/O					8			DAS
QC	Memo	0.00							36
Quality Control									9-89
									APR 27 2015
150		0.00							
150	Small Fab					8	FF		MAY 07 2015
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D3650								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Item Name: Fwd Panel

Stop

NS2

Start Date: 4/17/2015 Start Qty: 6.00

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Cust Item ID:

Required Date: 4/24/2015 Req'd Qty: 6.00

6

Customer:

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Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

(8)

38
9-88

MAY 08 2015

170

Identify as per dwg & Stock Location

0.00

170

Packaging

Memo

0.00

Packaging

8

DAW
27
9-88

MAY 11 2015

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MCS

MAY 12 2015

W 1505-11

DQA: _____ Date: _____



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Picklist Print

Friday, April 17, 2015 8:40:22 AM

Page 1

Work Order ID: 131598

131598

Parent Item: D3650-5

D3650-5

Parent Item Name: Fwd Panel

Start Date: 4/17/2015

Required Date: 4/24/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPR Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3650-7 *D3650-7* Seal		Manufactured	No			150	Each	2.0000	1	6			
				<u>Location</u> 131904			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA 126316			2			2			
				97211			2			2			
D3650-9 *D3650-9* Angle		Manufactured	No			150	Each	5.0000	1	6			
				<u>Location</u> 132224			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA 131911			5			5			
				126207			5			5			
D3893-1 *D3893-1* Doubler		Manufactured	No				Each	16.0000		6			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			16						
				95335			4			4			
				96812			12			12			
M304S26GA *M304S26GA* 304/316 0.018 SHEET		Purchased	No			150	sf	79.6567	0.813				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MAT020			79.6567						
				m130650			79.6567						

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FF

MAY 07 2015

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FF

MAY 07 2015

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MAY 07 2015

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Jm15-418

30650.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Friday, April 17, 2015 8:40:22 AM

Page 2

Work Order ID: 131598

Parent Item: D3650-5

Parent Item Name: Fwd Panel

131598

D3650-5

Start Date: 4/17/2015

Required Date: 4/24/2015

Start Qty: 6.00

Required Qty: 6.00

MS20427M3-3

Purchased

No

150

Each

889.0000

8

48

MS20427M3-3

Rivet

**

FF

MAY 07 2015

Location

Loc Qty

Loc Code

GA

17

m129864

7

m130922

10

ST311

872

131677

373

m130922

499

640

MS21060-3K

Purchased

No

150

Each

191.0000

2

12

MS21060-3K

Nut Plate

**

FF

MAY 07 2015

Location

Loc Qty

Loc Code

GA

81

m130953

81

ST302

110

m129864

1

m131153

109

16

MS21062-3K

Purchased

No

110

Each

106.0000

2

12

MS21062-3K

Nut Plate

**

FF

MAY 07 2015

Location

Loc Qty

Loc Code

ST301

106

M131153

106

16

Friday, April 17, 2015 8:40:22 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER :																							

Picklist Print

Friday, April 17, 2015 8:40:22 AM

Page 3

Work Order ID: 131598

131598

Parent Item: D3650-5

D3650-5

Parent Item Name: Fwd Panel

Start Date: 4/17/2015

Required Date: 4/24/2015

Start Qty: 6.00

Required Qty: 6.00

NAS9307/M-4-03

Purchased

No

150

Each

499.0000

12

72

NAS9307/M-4-03

FF

MAY 07 2015

RIVET

Location

Loc Qty

Loc Code

GA

499

124561

199

124778

300

96

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

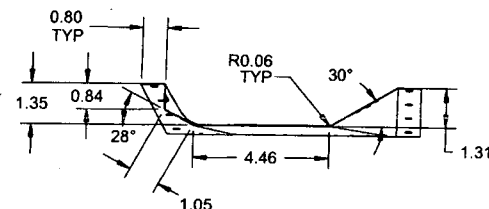
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OTHER : ☐																									

QTY	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
1	D3893-1	DOUBLER
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

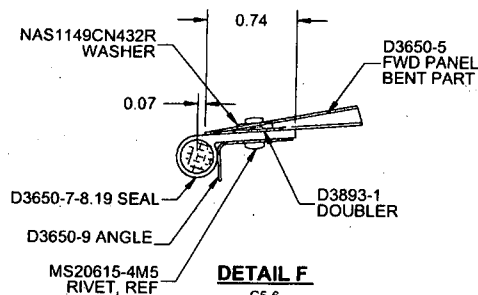
MS21062-3K NUTPLATE (1X)
MS20427M3-3 RIVET (2X)
2 PL

MS21060-3K NUTPLATE (1X)
MS20427M3-3 RIVET (2X)
2 PL

D3650-5B
FWD PANEL
BENT PART



MF
13598



DETAIL F
CS-6

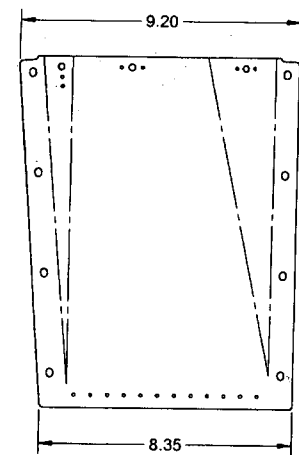
D3650-9
REF

D3650-7-8.19
REF

D3650-5B
FWD PANEL
BENT PART
REF

CENTRE D3650-7-9 ON D3650-5B &
TRANSFER Ø0.129 HOLES
FROM D3650-9 TO D3650-7 & D3650-5B
AS SHOWN
INSTALL
MS20615-4M5 RIVET
NAS1149CN432R WASHER
12 PL

D3650-5 FWD PANEL



D3650-5B FWD PANEL BENT PART

RELEASED
2012-10-09

- NOTES:
- 1) MATERIAL: MAKE FROM D3650-5F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.8 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RR	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ST	DRAWING NO.	REV. E
MFG. APPR.	AL	D3650	SHEET 6 OF 8
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	TOP PANEL ASSEMBLY	NTS
DATE	12.10.01	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause		FAULT CATEGORY																							
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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